

## CLAIMS

1. A heat-shrinkable polyester film having a multi-layer structure of at least two layers, among which at least one layer is a layer containing a PET bottle-recycled material, wherein a heat shrinkage percentage of a 10 cm square sample cut out from the film in a maximum shrinkage direction is 40 % or higher, under the condition that the square sample is immersed in hot water of 95°C for 10 seconds and then immersed in water of 25°C for 10 seconds, and the film contains as polyester components constituting the film, 50 % by mole or greater of a terephthalic acid component in 100 % by mole of polybasic carboxylic acid components, and 50 % by mole or greater in 100 % by mole of polyhydric alcohol components.

2. The heat-shrinkable polyester film as claimed in Claim 1 which has a multi-layer structure of at least three layers, wherein both surface layers have a content of the PET bottle-recycled material of 7 mass% or smaller, and at least one layer having a content of the PET bottle-recycled material of 7 mass% or larger is provided as an inner layer other than the surface layers.

3. The heat-shrinkable polyester film as claimed in Claim 1 or 2, wherein the film has an intrinsic viscosity of 0.62 dl/g or larger.

4. The heat-shrinkable polyester film as claimed in any one of Claims 1 to 3, wherein the film contains an alkaline earth metal and a

phosphorus compound, the content of the alkaline earth metal M<sup>2</sup> is from 20 to 400 ppm and the content of phosphorus atoms P is from 20 to 600 ppm in the film.

5. The heat-shrinkable polyester film as claimed in any one of Claims 1 to 4, wherein the film has a melting specific resistance at 275°C of  $0.4 \times 10^8$  ( $\Omega \cdot \text{cm}$ ) or less.

6. The heat-shrinkable polyester film as claimed in any one of Claims 1 to 5, wherein when the film stored in an environment controlled to a temperature of 30°C and a relative humidity of 85% for 28 days and then a plurality of the film specimens are subjected to a tensile test in a direction orthogonal to the maximum shrinkage direction in a condition of a distance between corresponding chucks of 100 mm, a specimen width of 15 mm, a temperature of 23°C and a tension test rate of 200 mm/min, the number of specimens with a breaking extension of 5% or less is 20% or less of all the specimens.

7. A heat-shrinkable label which uses the heat-shrinkable polyester film defined in any one of Claims 1 to 6.